

Work Order ID 99222

April-03-13 1:06:17 PM

99222

Ship tomorrow

Page 1

Item ID: D4791-6

Accept

N900040100

Setup Start

NS1

Revision ID: PRELIM

Item Name: Aft C-Channel

Stop

NS2

Start Date: 4/03/13

Start Qty: 2.00

2

Cust Item ID:

Required Date: 4/03/13

Req'd Qty: 2.00

2

Customer:

PRELIMINARY ISSUE

Reference:

Approvals:

Process Plan:

WMC

Date:

13-4-03

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
----------	--------------

D4791	PA3
-------	-----

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg (D4791-5F)

Dwg Rev: PA3

Prog Rev: PA3

2-Deburr as required

110

0.00

110

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

3

DAS 05 13-04-03

3

DAS 05 13-04-03

Work Order ID 99222

99222

Page 2

April-03-13 1:06:17 PM

Item ID: D4791-6 Accept *N900040100* Setup Start *NS1*
 Revision ID: PRELIM Stop *NS2*
 Item Name: Aft C-Channel
 Start Date: 4/03/13 Start Qty: 2.00 *2* Cust Item ID:
 Required Date: 4/03/13 Req'd Qty: 2.00 *2* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00 13.44				3 Inspected as per Dup PAS			
140 *140* Brake NC Brake NC	Form as per dwg NC BRAKE Memo Bend as per Dwg D4791	0.00 0.00				2	1		13/04/04 R.C. Bend Development
150 *150* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00 13.44				2 Inspected as per Dup PAS			

Work Order ID 99222

99222

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April-03-13 1:06:17 PM

Item ID: D4791-6 Accept *N900040100* Setup Start *NS1*
Revision ID: PRELIM Stop *NS2*
Item Name: Aft C-Channel
Start Date: 4/03/13 Start Qty: 2.00 *2* Cust Item ID:
Required Date: 4/03/13 Req'd Qty: 2.00 *2* Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Chemical Conversion Coat per QSI005 4.1	0.00							
160									
HandFinish	Memo	0.00							
Hand Finishing									
170	QC7-Inspect Chemical Conversion Coat	0.00							
170									
QC	Memo	0.00							
Quality Control									
180	Identify as per dwg & Stock Location: _____	0.00							
180									
Packaging	Memo	0.00							
Packaging									

2 7613-45

DAS
16
9-88 1316465
to PAB 200 wh.

Work Order ID 99222***99222***

Page 4

April-03-13 1:06:17 PM

Item ID: D4791-6 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: PRELIM Stop ***NS2***
Item Name: Aft C-Channel
Start Date: 4/03/13 Start Qty: 2.00 ***2*** Cust Item ID:
Required Date: 4/03/13 Req'd Qty: 2.00 ***2*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.00							
Quality Control									

POSITIVE RECALL

EFFECTIVE _____ AUTH _____

RELEASED _____ DATE _____

mf
13-4-5

Picklist Print

April-03-13 1:06:17 PM

Work Order ID: 99222

Parent Item: D4791-6

Parent Item Name: Aft C-Channel

Start Date: 4/03/13

Required Date: 4/03/13

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:B 13-03-22 AS PER REV.PA2 DD VERIFIED BY:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.063 6061-T6 .063 Sheet		Purchased	No				sf	243.3625		<u>0.5936842</u>		4/13/04/03	

Location

Loc Qty

Loc Code

MAT021

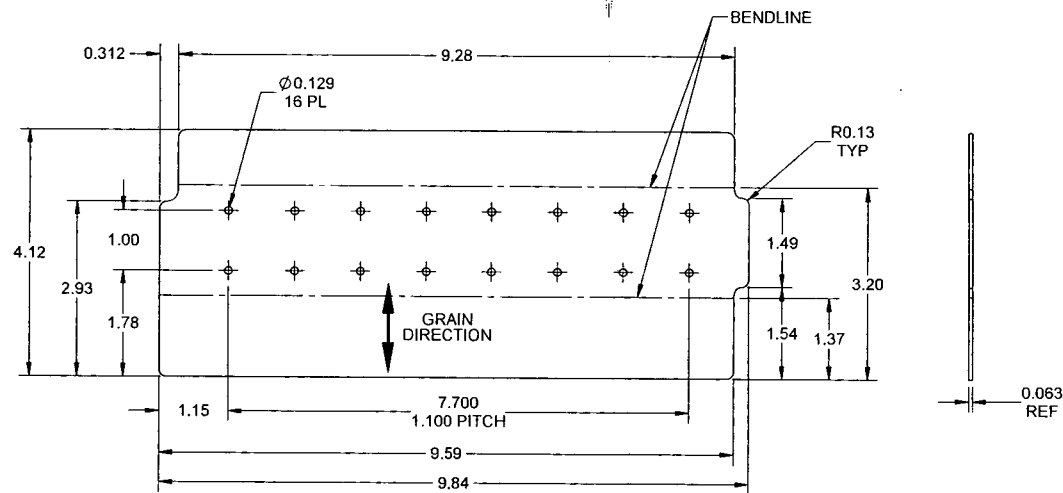
243.3625

123135

120.5625

124003

122.8



D4791-5F FLAT PATTERN

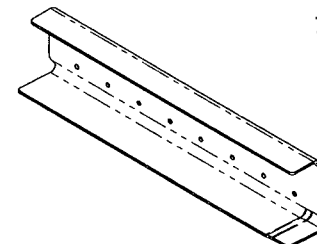
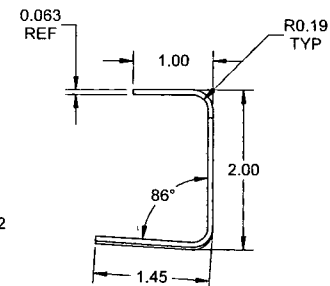
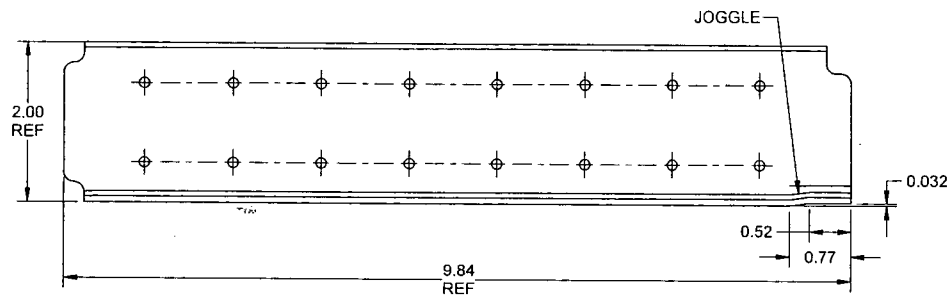
PRELIMINARY ISSUE

13.03.02

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET 0.063 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M2024T3S.063 OR M6061T6S.063
OR
2024-T3 ALUMINUM SHEET, 0.063 THICK
QQ-A-250/4 OR AMS-QQ-A-250/4 OR AMS 4037 OR ASTM B209
REF DART SPEC M6061T6S.063 OR M2024T3S.063
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.24 lbs

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	DC	DRAWING NO.	REV. PA3
MFG. APPR.		D4791	SHEET 10 OF 11
APPROVED		TITLE	SCALE
DE APPR.		AFT C-CHANNEL ASSEMBLY	NTS
DATE	13.03.02	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR CLAIMED OR COMMUNICATED TO ANY OTHER PERSON OR ENTITY WITHOUT PERMISSION FROM DART AEROSPACE LTD.	



D4791-6 AFT C-CHANNEL

PRELIMINARY ISSUE

~~REV~~ 13.03.02

NOTES:

- 1) MATERIAL: MAKE FROM D4791-5 FLAT PATTERN
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.24 lbs

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>JC</i>	DRAWING NO. D4791	REV. PA3
MFG. APPR.			SHEET 7 OF 11
APPROVED		TITLE	SCALE
DE APPR.		AFT C-CHANNEL ASSEMBLY	NTS
DATE	13.03.02	<small>COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESSED CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

DART AEROSPACE LTD		Work Order: 1599222
Description: aft c channel		Part Number: 104791-6
Inspection Dwg: 104791	Rev:	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.00	± 0.030	2.025	✓			✓
9.84	± 0.030	9.85	✓			✓
0.52	± 0.030	0.519	✓			✓
0.77	± 0.030	0.768	✓			✓
0.032	± 0.030	0.0319	✓			✓
0.063	± 0.010	0.0615	✓			✓
1.00	± 0.030	0.992	✓			✓
1.45	± 0.030	1.465	✓			✓
86°	± 5	86°	✓			✓
R0.19	± 0.030	.19	✓			✓

Measured by: ^{QAS} 21
Date: 13.4.4

Audited by:
Date:

Preliminary Approval:
Date:

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

Receiving Report

Date: 12-12-11
 Supplier: Campi

Batch No: 124003
 Dart P/O: 186008

Packing Slip: Yes ☒ No ☐
 Invoice: Yes ☒ No ☐
 Receipt: Cash ☐ Cr ☒

Release Note Attached: Yes ☒ No ☐ N/A ☐
 Waybill Attached: Yes ☐ No ☒ N/A ☐
 Shipment Complete: Yes ☒ No ☐ N/A ☐
 QC6 Inspection OK N/A ☒
 Work Order 2.4 N/A ☒

Discrepancies

Part Number	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments

Initials of receiver (if shipment OK) Level 12

SP

Production/Admin: 12-12-11
 Date
 Received/Costing SP
 Initial

Location _____

Page 1 of 1

All amounts are calculated in domestic currency.

Grouped by Vendor ID

[illegible]

935, boul. du Havre
Valleyfield (Québec)
J6S 5L1

TÉLÉPHONE : 450 377-4248
FAX : 450 377-5696

MONTREAL : 514 336-4248
FAX : 514 336-4246

DISTRIBUTEUR D'ACIER ET MÉTAUX SPÉCIALISÉS
STEEL AND SPECIALTY METALS DISTRIBUTOR

ONTARIO : 1 800 667-4248
FAX : 1 866 456-4242

On a du Savoir "FER"

VENDU À / SOLD TO:

613-632-5200

613-632-1053

EXPÉDIEZ À / SHIP TO:

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY,
ONTARIO
K6A 1K7

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY,
ONTARIO
K6A 1K7

EQUIPMENT LIFT

COMMANDE
ORDER


N° 209069

DATE:

07/12/12

BON DE LIVRAISON **N°**
PACKING SLIP

DATE DE LIVRAISON 11/10/12/12
DELIVERY DATE

VOTRE N° DE COMMANDE / YOUR PO. N°	VEND. / SALESM.	CODE CLIENT / CUST. CODE	EXPEDIE PAR / SHIP VIA	TERMES / TERMS	TERR	REMARQUES / REMARKS	PAGE N°
P018600	V	DAER		NET 30 JOURS	2R		001

[illegible]

* Unités de mesure: CLB Cent livres • CPI Cent pieds • UN Unité • PI Pied • PC Pied carré
Units of measure: Hundred pounds • Hundred feet • Unit • Foot • Square foot

POIDS TOTAL	
TOTAL WEIGHT	

CONDITIONS

[illegible]

CONDITIONS

ALL SOLD AND DELIVERED MATERIALS REMAIN THE PROPERTY OF "ASHER CAMPING," UNTIL PAYMENT IS MADE IN FULL, COMPLETE AND CASHED. ALL OTHER MATERIALS ARE AT THE BUYER'S EXPENSE. * ALL MATERIALS BEAR THE SAME WARRANTY AS GIVEN BY THE MANUFACTURER. THE BUYER AGREES TO REJECT THE FOLLOWING CONDITIONS: NET 30 DAYS FROM BILLING DATE AND THE BUYER ACCEPTS TO PAY THE FOLLOWING CONDITIONS: NET 30 DAYS FROM BILLING DATE. * ALL ACCOUNTS OVER 90 DAYS * ANY DEFAULT IN PREFERENCE WITH THE ADMINISTRATION CHARGES OF 2% PER MONTH. * ALL ACCOUNTS OVER 90 DAYS * ANY DEFAULT IN PREFERENCE WITH THE REPOSSESSION OF THE GOODS SOLD. * ANY CLAIM MUST BE MADE WITHIN FIVE DAYS WITH THIS DOCUMENT DELIVERED. * ANY CLAIM HAS BEEN DAMAGED, CUT OR MODIFIED CANNOT BE RETURNED. * ALL GOODS RETURNED MUST BE WITH ORIGINAL INVOICE AND ARE SUBJECT TO A 25% RESTOCKING CHARGE.

MARCHANDISE RECUE EN BONNE CONDITION MERCHANDISE RECEIVED IN GOOD CONDITION

SOUS-TOTAL
SUB TOTAL

T.P.S.
G.S.T.

T.V.Q./TVH
Q.S.T./HST

TOTAL

PRÉPARÉ / PREPARED.	VÉRIFIÉ / VERIFIED	LIVRÉ / DELIVERED	HEURE / TIME
PAR BY	PAR BY	PAR BY	

N° ENR. TPS / GST RF R 135 534 717 • N° ENR. TVQ / GST REG. N° 1 015 068 543

SIGNATURE DU CLIENT / CUSTOMER'S SIGNATURE

CERTIFIED INSPECTION REPORT

Alcoa Inc.

DAVENPORT WORKS 4879 State Street Bettendorf, IA 52722

Ship From: RIVERDALE, IA.

We hereby certify that the material covered by this certificate has been inspected with, and has been found to meet the applicable requirements described therein, including any specifications forming a part of the description and that samples representative of the material met the composition limits and had the mechanical properties shown on the face of this sheet.

This test report shall not be reproduced except in full, without the written approval of the Quality Department. No alteration, addition or other change is authorized to be made to this certificate. The recording of false, fictitious, or otherwise fraudulent statements or entries on this certificate by any recipient may be punished as a felony under applicable law.

Per:

Rob Woodall

Rob Woodall
Director of Manufacturing Davenport Works

Terrance Thom

Terrance Thom
Quality Assurance Manager

1381354	0			
Ship Date	B.L. No.	Invoice No.	Alcoa No.	Item
2012-05-16	7036272	00000	1000363803-3	DPE-63803-3
P.O. No./Govt Contract No.	Customer	Alcoa Item		
C64813 Ln#: 3				

Page 1 of 2

Ship To:

Item Description

0.063 IN TK (+0.0000 - .0035) X 48.0 IN W (+.125 - .135) X 144.0 IN LN (+.15625 - .15625) (N) A/T 6061-T6 PLAT SHEET FOR DISTRIBUTORS TOLERANCE GUARANTEED. AMS4027 REV N EXC MRK ASME-SB-209 REV 11 EXC MRK ASTM209 REV 10 CMMPO25 REV U ((MARKED)) KRAFT PAPER INTERLEAVED MAX GROSS SKID WGT: 4500 LB QUAN TOL +/-30 % CQR 0222751 REV 07 CUST REQ 12-05-12 *** W/E 12-05-26 ***

Num	Package Ticket	Lot	Weight	Quantity	UOM	Inspector Clock Numbers
1	411520	463274	4081	100	PC	27649 47004 2892116
2	411522	463274	4087	100	PC	27649 47004 2892117
3	411528	463274	3105	76	PC	27649 47004 2892118
			11273	276		

Notes for CQR: 0222751.7

PRODUCT PRODUCED TO THE REQUIREMENTS OF AMS4027 REV N ALSO MEET THE REQUIREMENTS OF AMS-QQ-A-250_11 ORIGINAL REVISION DATED 1997-08-01.

CQR: 0222751.7 -Specification Limits

Temp	Dir	Max	Min	UTS KSI	TYS KSI	EL4D PCT
T6	Long Transv.			42.0	35.0	10

DAV
05
12-12-12

CERTIFIED INSPECTION REPORT

Alcoa Inc.

DAVENPORT WORKS 4879 State Street Bettendorf, IA 52722

Ship From: RIVERDALE, IA.

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Per

Rob Woodall

Rob Woodall
Director of Manufacturing Davenport Works

Terrence Thom

Terrence Thom
Quality Assurance Manager

1381354
Ship Date

0

B.I. No.

Invoice No.

Alcoa No. Item

2012-05-16

7036272

00000

1000363803-3

DPE-63803-3

P.O. No./Govt Contract No.

Customer

Alcoa Item

C64813 Ln#: 3

Page 2 of 2

CQR: 0222751.7 -Specification Limits (cont.)

Chemical Composition		SI	FE	CU	MN	MG	CR	ZN	TI	Other-Other	
										Each	Total Aluminum
	Max	0.8	0.7	0.40	0.15	1.2	0.35	0.25	0.15	0.05	0.15
	Min	0.40		0.15		0.8	0.04				REMAIN

Alloy 5061 - Mechanical, Physical, Metallography, Quantometer Results

Lot: 463274	No->	UTS	TYS	EL4D
Temp	Dir	KSI	KSI	PCT
T6	Long Transv.	10	51.1	44.8
			50.9	44.7
			51	44.7
			51	44.7
			51	44.7
			50.5	44
			50.7	44.4
			50.5	44.2
			50.5	44.2
			50.6	44.4

Cast Number	Chemical - OES	SI	FE	CU	MN	MG	CR	ZN	TI
H9479082	Actuals	0.66	0.4	0.27	0.06	0.9	0.17	0.03	0.02

This material was melted in the United States or a Qualifying Country [REF DPAKS 225.872.1(a)]; it was manufactured in the United States



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO18608

Purchase Order Date 12/07/12

PO Print Date 12/07/12

Page Number 1 of 1

Order From :

VC-CAM002

CAMPI STEEL
935 BOUL. DU HAVRE
VALLEYFIELD, QC J6S 5L1
CA

Contact Name

Vendor Phone 800 667 4248

Vendor Fax 450 377 5696

Vendor Account Nbr

Buyer

Chantal Lavoie

Requisition Nbr

Tax Resale Nbr

10127-2607

Terms

Net 30

Currency

CAD

FOB

Destination-Collect

Ship To :

DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

FAXED
12/12/12

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	M6061T6S.063	6061-T6 .063 Sheet	12/17/12 Yes	288.00 sf	Yours ppd	\$3.3750	\$972.00

Special Inst: MATERIAL: 6061-T6/T62 ALUMINUM
SHEET
AS PER QQ-A-250/11 OR AMS-QQ-A-
250/11 OR
AMS 4025 OR AMS 4027 OR ASTM B209

NOTE: RECEIVING DEPARTMENT WILL
BE CLOSE FOR INVENTORY ON
DECEMBER 13 AND 14

PO Total:

\$972.00

**MATERIAL CERTIFICATION
REQ'D UPON DELIVERY**

Change Nbr: 2

Change Date: 12/07/12

No substitution or deviation without
consent.

Certificate of Conformity or Material
Certification required - YES NO